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D135-751-011
Job Sheet 203380



Part No: D135-751-011

Job Qty: 1 pcs

Part Name: Skidtube with Standard Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/18/19

Job Tracking No:

Due Date: 11/29/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG DSI 9661 REV A, D3507 REV D IPP Rev:A 44353 New Issue JLM IPP Rev:B 06-12-18 As per Rev B JLM IPP Rev:C 07-12-11 ECN 1036 as per revB DD IPP Rev D 08.11.04 Added DT9431 to sequence 5 EC verf DD IPP Rev E 10.02.22 per PAR 09-043 EC verified: DD IPP Rev:F 10.06.09 remove seq110 DD verf:EC IPP Rev G 10.09.17 added D3507-1-bent EC verified:DD IPP REV:H 13.12.11 ECN13-619/ CHG002 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	Skidtubes - 1	1 pcs		11/29/19	0.00	4.60	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
140	QC 5	1 pcs		11/29/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
150	Handfinish - 1-1 Chemical-B4B	1 pcs		11/29/19	0.00	0.33	Handfinish - 1 - 1 - B4B		
							Handfinish - 1 - 2 - B4B		

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				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
160 QC 7	1 pcs	11/29/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	<i>MS</i>
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	

170 Skidtubes - 2 - B4B	1 pcs	11/29/19	0.00 1.00	QC 7 - 61	
				QC 7 - 81	
				QC 7 - 76	
				QC 7 - 79	
				Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
180 QC 10	1 pcs	11/29/19	0.00 0.00	Skidtubes - 4 - B4B	TF
				Skidtubes - 5 - B4B	BE
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
				QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
185 Handfinish - 6-1- Touch Up- B4B	1 pcs	11/29/19	0.00 0.10	QC 10 - 43	
				QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
				QC 10 - 68	DAS NOV 26 2019 68
				Handfinish - 6 - 1 - B4B	9-89
				Handfinish - 6 - 2 - B4B	
				Handfinish - 6 - 3 - B4B	★ NOV 26 2019
				Handfinish - 6 - 4 - B4B	
				Handfinish - 6 - 5 - B4B	
				Handfinish - 6 - 6 - B4B	
				Handfinish - 6 - 7 - B4B	
				Handfinish - 6 - 8 - B4B	
				Handfinish - 6 - 9 - B4B	
				Handfinish - 6 - 10 - B4B	
				Handfinish - 6 - 11 - B4B	
				Handfinish - 6 - 12 - B4B	
				Handfinish - 6 - 13 - B4B	
				Handfinish - 6 - 14 - B4B	
				Handfinish - 6 - 15 - B4B	
				Handfinish - 6 - 16 - B4B	
				Handfinish - 6 - 17 - B4B	
				Handfinish - 6 - 18 - B4B	
				Handfinish - 6 - 19 - B4B	
				Handfinish - 6 - 20 - B4B	
				Handfinish - 6 - 21 - B4B	
				Handfinish - 6 - 22 - B4B	
187 QC 7	1 pcs	11/29/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	

					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
					QC 7 - 76	
					QC 7 - 79	88
190 Skidtubes - 3 - B4B	1 pcs	11/29/19	0.00 1.00	Skidtubes - 1 - B4B		
				Skidtubes - 2 - B4B		
				Skidtubes - 3 - B4B		
				Skidtubes - 4 - B4B		
				Skidtubes - 5 - B4B		
				Skidtubes - 6 - B4B		
				Skidtubes - 7 - B4B		
200 QC 5	1 pcs	11/29/19	0.00 0.00	QC 5 - 10		
				QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18		
				QC 5 - 19		
				QC 5 - 22		
				QC 5 - 24		
				QC 5 - 3		
				QC 5 - 43		
				QC 5 - 49		
				QC 5 - 51		
				QC 5 - 58		
				QC 5 - 68	NOV 27 2019 68	
				QC 5 - 9	9-89	
				QC 5 - 50		
				QC 5 - 30		
				QC 5 - 40		
				QC 5 - 61		
				QC 5 - 81		
210 Handfinish - 2-1 Pressure-B4B	1 pcs	11/29/19	0.00 0.08	Handfinish - 2 - 1 - B4B		
				Handfinish - 2 - 2 - B4B	NOV 27 2019	
				Handfinish - 2 - 3 - B4B		
				Handfinish - 2 - 4 - B4B		
220 Spray Paint - 2 - B4B	1 pcs	11/29/19	0.00 0.25	Spray Paint - 1 - B4B		
				Spray Paint - 2 - B4B	RD 19.11.29	
				Spray Paint - 3 - B4B		
				Spray Paint - 4 - B4B		
					Plex 11/18/19 1:37 PM Dart.lajeunesse.marie	

225 QC 14	1 pcs	11/29/19	0.00 0.00	QC 14 - 15	
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	BEB 19-12-02
				QC 14 - 9	
				QC 14 - 68	
				QC 14 - 40	
				QC 14 - 19	
				QC 14 - 43	
				QC 14 - 24	
				QC 14 - 61	
				QC 14 - 81	
260 Handfinish - 4-1-Assembly-B4B	1 pcs	11/29/19	0.00 0.74	Handfinish - 4 - 1 - B4B	
				Handfinish - 4 - 10 - B4B	BEB 19-12-02
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
270 QC 5	1 pcs	11/29/19	0.00 0.00	Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	DAS DEC 03 2019 68 9-89
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
280 Packaging 1-1 - Pick Kit - B4B	1 pcs	11/29/19	0.00 0.00	QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				Packaging 1 - 1 - B4B	
				Packaging 1 - 2 - B4B	
				Packaging 1 - 3 - B4B	DAS 74 9-89
				Packaging 1 - 4 - B4B	
				Packaging 1 - 5 - B4B	
					DEC 04 2019

				Packaging 1 - 6 - B4B	
				Packaging 1 - 7 - B4B	
				Packaging 1 - 8 - B4B	
				Packaging 1 - 9 - B4B	
				Packaging 1 - 10 - B4B	
				Packaging 1 - 11 - B4B	
				Packaging 1 - 12 - B4B	
				Packaging 1 - 13 - B4B	
				Packaging 1 - 14 - B4B	
				Packaging 1 - 15 - B4B	
				Packaging 1 - 16 - B4B	
				Packaging 1 - 17 - B4B	
				Packaging 1 - 18 - B4B	
				Packaging 1 - 19 - B4B	
				Packaging 1 - 20 - B4B	
				Packaging 1 - 21 - B4B	
				Packaging 1 - 22 - B4B	
				Packaging 1 - 23 - B4B	
				Packaging 1 - 24 - B4B	
				Packaging 1 - 25 - B4B	
				Packaging 1 - 26 - B4B	
				Packaging 1 - 27 - B4B	
				Packaging 1 - 28 - B4B	
				Packaging 1 - 29 - B4B	
				Packaging 1 - 30 - B4B	
				Packaging 1 - 31 - B4B	
				Packaging 1 - 32 - B4B	
				Packaging 1 - 33 - B4B	
				Packaging 1 - 34 - B4B	
				Packaging 1 - 35 - B4B	
				Packaging 1 - 36 - B4B	
290 QC 4	1 pcs	11/29/19	0.00 0.00	QC 4 - 28	
				QC 4 - 58	
				QC 4 - 69	
				QC 4 - 9	
				QC 4 - 46	
				QC 4 - 68	
				QC 4 - 72	
				QC 4 - 74	
				QC 4 - 75	
				QC 4 - 78	
					DAS 78 DEC 04 2019 9-89
300 Packaging 3-1 - Stock - B4B	1 pcs	11/29/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
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				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	DAS
				Packaging 3 - 25 - B4B	78 DEC 04 2019
				Packaging 3 - 26 - B4B	9-89
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAS
305 DC - 1 - B4B	1	11/29/19	0.00 0.00	DC - 1 - B4B	21
	pcs			DC - 2 - B4B	9-89 DEC 04 2019
310 QC 21 - FG	1	11/29/19	0.00 0.00	QC 21 - FG - 21	DAS
	pcs			QC 21 - FG - 70	21
				QC 21 - FG - 53	9-89 DEC 04 2019

Part Op 120 - 1-Cut Aft end as per dwg D3507 3-Drill Aft & Fwd Cap holes using DT8678 & DT8901 4-Locate DT8870 & Drill Descriptions: Ground wire hole on top of Tube, 6-Locate DT8870 with #30 cleco in Ground wire hole, then Pilot Drill all X-Bolt holes using #30" drill. ****DO NOT OPEN AFT CAP HOLES**** 7-Open crossbolt holes to 0.3125" (3 per side). Drill pilot holes for wearplates using Dt8868, Use DT8892 FOR REAR WEARPLATE HOLES. 8-Open six rear wearplate holes using DT8892. Open all wearplate holes to 0.297" 9-Open ground wire hole .297" section E-E 10-Open Aft & Fwd Cap holes using .208" drill. 11-Bore out aft end of tube as per Dwg D3507 & Detail "B". 12- Section G-G holes must be laid out manually, open to #30. 13-Debur holes.

140 - (QC5- Inspect part completeness to step on W/O)

160 - (QC7-Inspect Chemical Conversion Coat)

170 - 1-Open X-Bolt holes to .375" (1 Places) & .500" (2 Places) as per Dwg D3507. and section G-G to .750" (2 places) 2-Counter Sink X-BOLT holes as per Dwg D3507 3-Debur and blow out chips from inside of tube. 4-Bond web as per Dwg D3507 & QSI 015 start time: 1:30pm Nov 21 end time: 1:30pm Nov 23 5-Weld x-bolt spacers as per Dwg D3507 and Detail C-C & D-D and G-G 7-Drill Rivet Holes as per Dwg D3507 Using Dt8871A&B 8-Debur Rivet holes.

180 - (QC10- Inspect visual per QSI004- ground welds)

185 - (Touch up alodine) RE-ALODINE ONLY

187 - (QC7-Inspect Chemical Conversion Coat)

190 - 1-Rivet D3506-1/-3 as per Dwg D3507.

200 - (QC5- Inspect part completeness to step on W/O)

210 - Touch-up alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

220 - (Spray Paint / NDT Room) 1- Apply Primer as per QSI 005 4.2.1.3.3 and dwg A/R Primer

Batch: 5200299 2- Paint two coats of White paint as per QSI 005 4.2 and dwg A/R Paint

Batch: 5231052

225 - (QC14- Inspect Spray Paint)

260 - 1- Install Wearplate & Ground Wire inserts as per Dwg D3507. 1-Inspect for Foreign objects 2-Install Fwd & Aft caps as per Dwg D3507 And Detail "A" & "B" 3-Install Wearplates as per Dwg D3507, Note: Install (1) Bolt and (1) washer on Ground Wire insert on top of tube Do not Install Scews where indicated on Dwg (Note #6) 4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube 5- Wing Walk as per Dwg D3507 and QSI 005 4.4 Batch: _____

270 - (QC5- Inspect part completeness to step on W/O)

280 - (Pick Kit)

290 - (QC4- 100% Inspect kits for completeness)

300 - (Identify as per dwg & Stock Location: _____) Identify and pack for shipping as per PPP D135-751-011 PPP

Rev: _____

305 - Photocopy bluefile & type labels per PPP D135-751-011 CHG002

310 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3507-1-BENT	Skidtube Assembly EC135	1 pcs (1 ea)	120-Skidtubes - 1	5232835
D3504-1	Crossbolt Spacer	2 pcs (2 ea)	170-Skidtubes - 2 - B4B	5140029
D3504-3	Crossbolt Spacer	1 pcs (1 ea)	170-Skidtubes - 2 - B4B	5213140
D3504-5	Crossbolt Spacer	2 pcs (2 ea)	170-Skidtubes - 2 - B4B	5222146
D3505-1	Web	1 pcs (1 ea)	170-Skidtubes - 2 - B4B	5154725
D3506-1	Doubler	4 pcs (4 ea)	190-Skidtubes - 3 - B4B	5226738x3
D3506-3	Doubler	2 pcs (2 ea)	190-Skidtubes - 3 - B4B	5226736
MS20601-AD4W3	Rivet	12 Ea (12 ea)	190-Skidtubes - 3 - B4B	5222195
ALS4-1032-225	Rivnut	1 Ea (1 ea)	260-Handfinish - 4-1-Assembly-B4B	5203363
ALS7-1032-130	Rivnut	38 Ea (38 ea)	260-Handfinish - 4-1-Assembly-B4B	5209194
AN3C4A	Bolt	31 Ea (31 ea)	260-Handfinish - 4-1-Assembly-B4B	5225279
AN3C5A	Bolt	2 Ea (2 ea)	260-Handfinish - 4-1-Assembly-B4B	5123445
AN526C1032R10	Screw	2 Ea (2 ea)	260-Handfinish - 4-1-Assembly-B4B	5166981
D2965	Cap	1 pcs (1 ea)	260-Handfinish - 4-1-Assembly-B4B	5166570
D2965-3	Cap	1 pcs (1 ea)	260-Handfinish - 4-1-Assembly-B4B	5166571
D3492-1	Plug	4 pcs (4 ea)	260-Handfinish - 4-1-Assembly-B4B	5218656
D3492-3	Plug	4 pcs (4 ea)	260-Handfinish - 4-1-Assembly-B4B	5215332
D3492-7	Plug	2 pcs (2 ea)	260-Handfinish - 4-1-Assembly-B4B	5219515
D4918-047	Wearplate Aft	1 pcs (1 ea)	260-Handfinish - 4-1-Assembly-B4B	5218948
D4918-1	Wearplate Fwd	1 pcs (1 ea)	260-Handfinish - 4-1-Assembly-B4B	5220080
D4918-3	Wearplate Center Fwd	1 pcs (1 ea)	260-Handfinish - 4-1-Assembly-B4B	5220102
D4918-5	Wearplate Center Aft	1 pcs (1 ea)	260-Handfinish - 4-1-Assembly-B4B	5220109
NAS1149C0332R	Washer (AN960C10L)	33 Ea (33 ea)	260-Handfinish - 4-1-Assembly-B4B	5252162
NAS1611-007	O-Ring	2 Ea (2 ea)	260-Handfinish - 4-1-Assembly-B4B	F103697
NAS1611-010	O-Ring	4 Ea (4 ea)	260-Handfinish - 4-1-Assembly-B4B	5217830
NAS1611-013	O-Ring	4 Ea (4 ea)	260-Handfinish - 4-1-Assembly-B4B	5218787
AN3C4A	Bolt	8 Ea (8 ea)	280-Packaging 1-1 - Pick Kit - B4B	5217707
D3512-041	Wearplate	2 pcs (2 ea)	280-Packaging 1-1 - Pick Kit - B4B	5234251
NAS1149C0332R	Washer (AN960C10L)	8 Ea (8 ea)	280-Packaging 1-1 - Pick Kit - B4B	5211548

M.U. 013221

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
120-Skidtubes - 1	D3507-1-BENT	1	0	0
170-Skidtubes - 2 - B4B	D3504-1	2	102	0
	D3504-3	1	94	0
	D3504-5	2	18	0
	D3505-1	1	5	0
190-Skidtubes - 3 - B4B	D3506-1	4	27	0
	D3506-3	2	28	0
	MS20601-AD4W3	12	736	0
260-Handfinish - 4-1-Assembly-B4B	ALS4-1032-225	1	882	0
	ALS7-1032-130	38	937	0
	AN3C4A	31	1,406	0
	AN3C5A	2	703	0
	AN526C1032R10	2	105	0
	D2965	1	32	0
	D2965-3	1	32	0
	D3492-1	4	104	0
	D3492-3	4	35	0
	D3492-7	2	36	0
	D4918-047	1	5	0
	D4918-1	1	6	0
	D4918-3	1	11	0
	D4918-5	1	11	0
	NAS1149C0332R	33	3,357	0
	NAS1611-007	2	214	0
	NAS1611-010	4	160	0
	NAS1611-013	4	62	0
280-Packaging 1-1 - Pick Kit - B4B	AN3C4A	8	1,406	0
	D3512-041	2	5	0
	NAS1149C0332R	8	3,357	0

Part Specifications

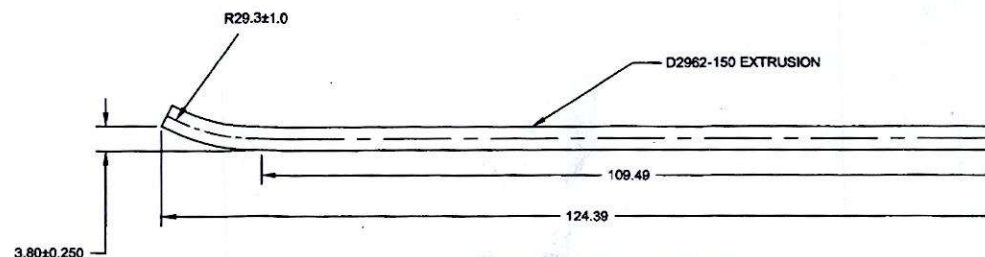
Specifications could not be found.

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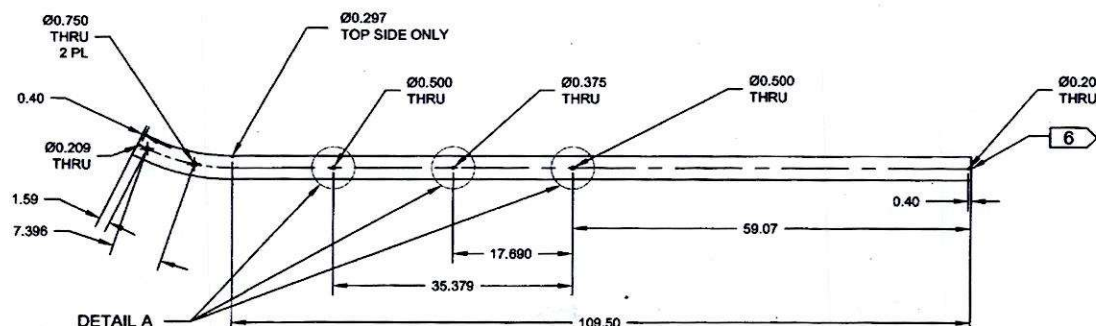
Qty	Part Number	Description
X	D3507-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2965	CAP
1	D2965-3	CAP
4	D3492-041	PLUG ASSEMBLY
4	D3492-043	PLUG ASSEMBLY
2	D3492-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3506-1	DOUBLER
2	D3506-3	DOUBLER
1	D4918-1	WEARPLATE
1	D4918-3	WEARPLATE
1	D4918-5	WEARPLATE
1	D4918-047	WEARPLATE
38	AELS-1032-130	INSERT
1	AELS-1032-225	INSERT
31	AN3C4A	BOLT
2	AN3C5A	BOLT
2	AN526C1032-10	SCREW
33	AN860C10L	WASHER
12	MS20601AD4W3	RIVET

GENERAL NOTES:

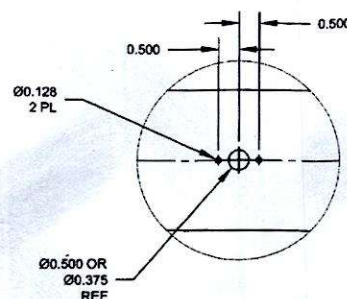
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3505-1 WEB.
 STANDARD: PRIME (REF. 4.2 1.3.3) AND PAINT WHITE PER DART QSI 005 4.2.
 OPTIONAL: POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3.
 BLACK ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTERLINE PER DART QSI 005 4.4 (OPTIONAL)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART B/N PER DART QSI 044 6.4 (VIBRATING STYLUS) ON I.D. OF TUBE
- 7) WEIGHT: 24.1 LB (FROM IN-D135-751)
- 8) WELDING TO BE DONE PER DART QSI 004
- 9) INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING
- 10) USE DART DRILL TEMPLATE DT8868 TO LOCATE AND DRILL Ø0.297 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION C-C (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- 11) DO NOT INSTALL AN3C4A BOLTS AND AN860C10L WASHERS IN INDICATED LOCATIONS



D3507-1 BENDING/CUTTING DETAIL



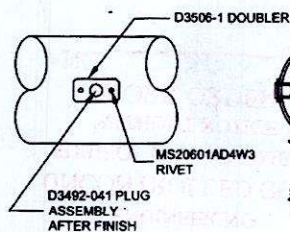
D3507-1 DRILLING DETAIL



DETAIL A
TYP, 6 PL
SCALE 3:10

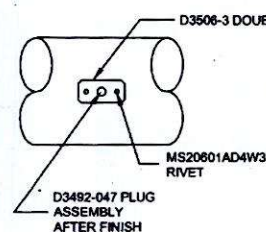
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 203380 M15
19-11-18

D	REMOVE D3558-X GASKETS, D4918-X WAS D3508-X REVISE FINISH TO ADD PAINT AS THE PREFERRED FINISH. REVISED NOTES	DW	13.08.30
C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MAT'L	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION		BY DATE
DESIGN	DW	DART AEROSPACE USA, INC	
DRAWN	DW	KENT, WA	
CHECKED	JP	DRAWING NO.	REV. D
MFG. APPR.	JP	D3507	SHEET 1 OF 2
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	EC 135 SKIDTUBE	NTS
DATE	13.08.30	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC	
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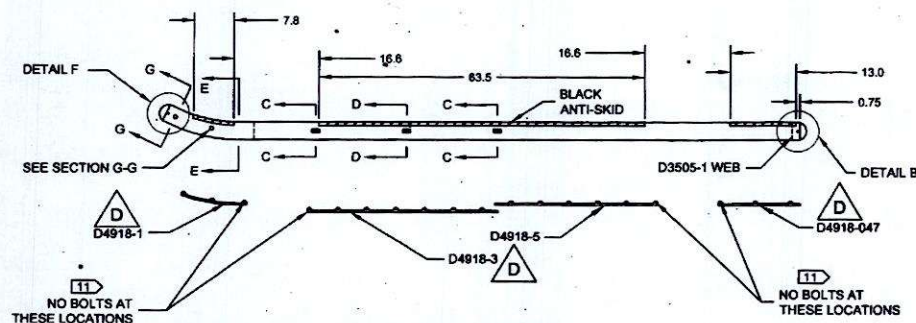
SECTION C-C
(SCALE 3:10)

- D3504-1 CROSS BOLT SPACER**
- AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.500 HOLES ONLY:
1. CHAMFER HOLE 0.030 x 45°
 2. INSERT D3504-1 CROSS BOLT SPACER 2 PL
 3. WELD INTO PLACE AND GRIND FLUSH
 4. IF REQUIRED, PASS Ø0.404 (Y DRILL) THRU HOLE
 5. INSTALL D3506-1 DOUBLER 4 PL USING MS20601AD4W3 RIVET 8 PL
 6. AFTER FINISH, INSTALL D3492-041 PLUG ASSEMBLY 4 PL

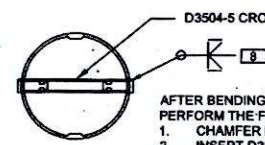


SECTION D-D
(SCALE 3:10)

- D3504-3 CROSS BOLT SPACER**
- AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.030 x 45°
 2. INSERT D3504-3 CROSS BOLT SPACER 1 PL
 3. WELD INTO PLACE AND GRIND FLUSH
 4. IF REQUIRED, PASS Ø0.277 (Y DRILL) THRU HOLE
 5. INSTALL D3506-3 DOUBLER 2 PL USING MS20601AD4W3 RIVET 4 PL
 6. AFTER FINISH, INSTALL D3492-047 PLUG ASSEMBLY 2 PL

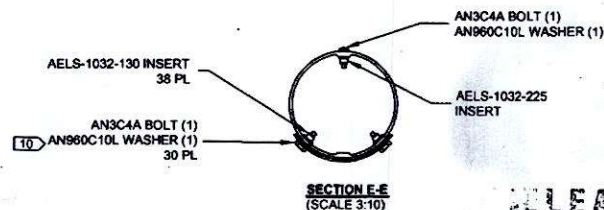
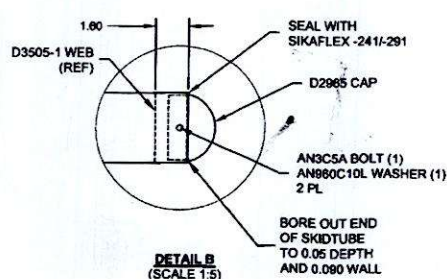
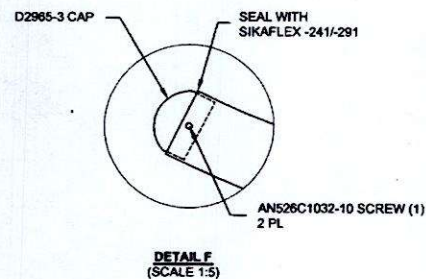


D3507-041 ASSEMBLY DETAIL



SECTION G-G
(SCALE 3:10)

- AFTER BENDING AND DRILLING
PERFORM THE FOLLOWING FOR Ø0.750 HOLES ONLY:
1. CHAMFER HOLE 0.030 x 45°
 2. INSERT D3504-5 CROSS BOLT SPACER 2 PL
 3. WELD INTO PLACE AND GRIND FLUSH
 4. IF REQUIRED, PASS Ø0.594 (19/32 DRILL) THRU HOLE
 5. AFTER FINISH, INSTALL D3492-043 PLUG ASSEMBLY 4 PL



RELEASED
2013-12-10

DESIGN	DW	DART AEROSPACE USA, INC	
DRAWN	DW	KENT, WA	
CHECKED	GP	DRAWING NO.	REV. D
MFG. APPR.		D3507	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		EC 135 SKIDTUBE	NTS
DATE	13.08.30	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC	
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					



Container No: S233396



Part: D135-751-011

Job No: 203380

Serial No/Batch: S233396

Revision:

Inspector:

Exp Date:

Instructions: FAA STC SR01709SE 18/02/17, T6, LoA RDIMS

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